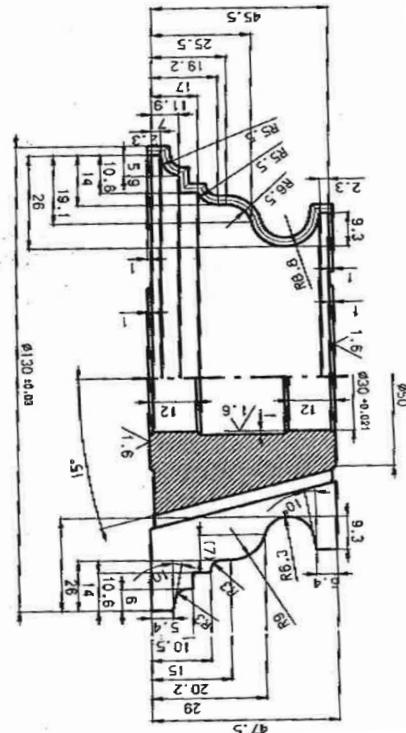


ShearAngle Profile Tool Ø130 Z4

A16-200

Roughing of the profile is done in plunge grinding. Pregrinding and finishing of the profile is ground using standard 14EE1 Profilewheels and automatic calculation of the wheelorientation to achieve the required radial and axial clearance. Probing is measuring Shear-, Rakeangle and division if necessary.



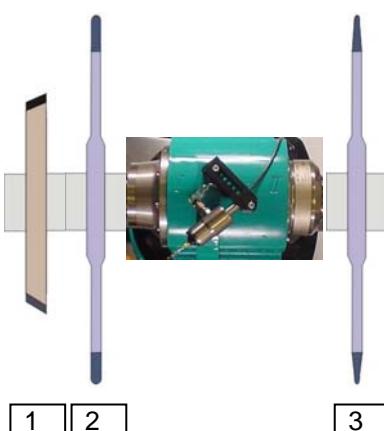
1. Cyclic time for Production

Workpiece:	Ø 130 mm, Z 4, Length of cutting edge 48 mm, shear angle 5° Material CARBIDE				
Operations	Probe	Flute 1	Prf Rough	Prf Pgnd	Prf fin
Feed [mm/Min]	2000	70	90	70	100
Power [kW]		3	2	1	1
Cutting feed [m/s]		22	20	22	22
Used wheels		1	2	3	3
Grinding time [s]	30	260	2027	280	201
Total cycle time	46 Min 38				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1V1 Ø125 D64
2	14F1 Ø200 D76R1.5
3	14EE1 Ø200 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders · NORMA CEG

Control: Fanuc 310i

Accessories:

Responsible engineer: OP 3.8.10

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

www.schneeburger.ch

www.schneberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Ruggwil Switzerland
Subsidiaries in: France Deutschland Italia United States UK

Subsidiaries in: France, Deutschland, Italia, United States, UK, China